

Date: Sunday, 12/4/2005 12:45:08 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP LEG	
Job Number :	25089B			
Estimate Number :	10353			
P.O. Number :	N/A	Part Number :	D2278	
This Issue :	12/4/2005	S.O. No. :	N/A	
Prsht Rev. :	NC	Drawing Number :	D2278 REV D	
First Issue :	N/A	Project Number :	N/A	
Previous Run :	24533B	Drawing Revision :	D	
	Type : SMALL /MED FAB	Material :	N/A	
Written By :	See comment below		Due Date :	12/12/2005
Checked & Approved By :	See comment below		Qty:	40 Um: Each
Comment :	Est Rev:A New Issue 05-11-07 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s)
 Material: 5052-H32 sheet (QQ-A-250/8) 0.080" Thick
 (M5052H32S.080)
 Identify as D2278
 Batch: M19052

2.0	SHEAR	SHEAR J.L	05.12.10 40
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Comment: SHEAR
 Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 J.L	05.12.10 40
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2278, use stack of 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE J.L	05.12.10 40
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

9m 05.12.10 40

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: S Date: 05/12/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

SAD 118/12/05/40

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SAD 118/12/05/40

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

05-12-19

40

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

SD 05/12/19

40

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

545 05/12/21 (40)

SD 05/12/21

40

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

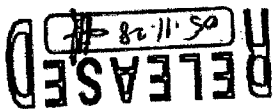
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1) MATERIAL:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET (QQ-A-250/8 OR AMS 4016) 0.080 THICK
(REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN BW		DRAWN BY BH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED BH		APPROVED BH		DRAWING NO. D2278	
DATE 05.11.14		TITLE LEG		SCALE 1:2.5	
C		95.02.16		CHANGED RADIUS TO 0.354	
D		05.11.14		ADD FINISHING NOTE	



1000

1000

